

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014020**Date Inspected:** 13-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

OBG SEGMENT 7EE

MAGNETIC PARTICLE INSPECTION

ZPMC NWIT No: 005722

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the longitudinal diaphragm hold back. The welds Designation are as follows.

SEG042B-021, 022

SEG042C-009, 010

OBG SEGMENT 8BE

MAGNETIC PARTICLE INSPECTION

WELDING INSPECTION REPORT

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ZPMC NWIT No: 005722

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as longitudinal diaphragm. The welds Designation are as follows.

SEG046B-022, 024, 006

SEG046C-001, 007, 009

OBG SEGMENT 8BE-8CE

MAGNETIC PARTICLE INSPECTION

ZPMC NWIT No: 005722

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as longitudinal diaphragm. The welds Designation are as follows.

SEG046B-027, 028

SEG046C-011, 012

SEG048D-009, 010

SEG048F-009, 010

OBG SEGMENT 7EE-8AE

MAGNETIC PARTICLE INSPECTION

ZPMC NWIT No: 005722

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as "T" and "I" rib stiffeners. The welds Designation are as follows.

DP658-001-017, 018; DP659-001-011, 012; DP666-001-013, 014; DP667-001-007, 008; EP093-001-009, 010; EP094-001-006, 007; SP465-001-025, 026; SP466-001-015, 016; SP314-001-035~038; SP315-001-007~010; SP341-001-025~028; SP342-001-001~004; SP368-001-033~036; SP369-001-009~012; BP120-001-033~036; BP121-001-033~036; BP174-001-037~040; BP175-001-037~040; BP066-001-033~036; BP067-001-033~036; SP616-001-025~028; SP617-001-031~034; SP536-001-035~038; SP537-001-028~031; SP576-001-029~032; SP577-001-022~025; SP455-001-023, 024; SP456-001-023, 024; EP083-001-009, 010; EP084-001-010, 011.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing Flux Cored Arc Welding process for weld SEG043A-044 located on PCMK. Longitudinal diaphragm to bottom panel. ZPMC QC

WELDING INSPECTION REPORT

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Mr. Cai Xiao Feng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067876 performing Flux Cored Arc Welding process for weld SEG043A-045 located on PCMK. Longitudinal diaphragm to bottom panel. ZPMC QC Mr. Cai Xiao Feng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-2.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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